

What Is Claimed Is:

1. A method for curing one or more coatings on an automotive body comprising:
 - (i) coating the automotive body with at least one electron beam curable coating;
and
 - 5 (ii) moving the automotive body one or more times through one or more medium to high power, medium to high energy electron beams.
2. The method of claim 1 where the automotive body is moved one or more times through one or more high power high energy electron beams.
3. The method of claim 1 where the automotive body is moved by a continuous
10 conveyor system into a vault that has a plurality of electron beam scanning units which deliver medium to high energy electron beams, generated by one or more accelerators, on opposite sides of the automotive body.
4. The method of claim 3 where the automotive body moves through the vault multiple times.
- 15 5. The method of claim 1 where a single electron beam accelerator and scanning unit is employed and a continuous conveyor tilts the automotive body to face the beam as it moves through a vault.
6. The method of claim 5 where the automotive body moves through the vault multiple times.
- 20 7. The method of claim 1 where the automotive body is coated with an electrocoat, a primer, a basecoat and a clear coat.
8. The method of claim 7 where the basecoat is an electron beam curable coating.
9. The method of claim 1 where the electron beam curable coating is an
25 unsaturated oligomer or polymer.
10. The method of claim 9 where the electron beam curable coating is an acrylate functional oligomer or polymer.

11. A method for curing one or more coatings on an automotive body comprising:
(i) coating the automotive body with at least one X-ray curable coating; and
(ii) moving the automotive body one or more times through one or more X-ray
fields generated by striking a metal target with a medium to high power, medium to high
5 energy electron beam.

12. The method of claim 11 where the automotive body is moved one or more
times through one or more X-ray fields generated by striking a metal target with a high
power high energy electron beam.

13. The method of claim 11 where the automotive body is moved by a conveyor
10 through a vault where the automotive body is immersed in a single X-ray field.

14. The method of claim 13 where the automotive body moves through the vault
multiple times.

15. The method of claim 11 where the automotive body is moved by a conveyor
through a vault where the automotive body is immersed in a plurality of X-ray fields.

16. The method of claim 15 where the automotive body passes through the vault
multiple times.

17. The method of claim 11 where the automotive body is coated with an electro-
coat, a primer, a basecoat and a clear coat.

18. The method of claim 17 where the basecoat is an X-ray curable coating.

19. The method of claim 11 where the X-ray curable coating is an unsaturated
20 oligomer or polymer.

20. The method of claim 19 where the X-ray curable coating is an acrylate
functional oligomer or polymer.

21. A method for curing one or more coatings on an object made from a sheet
25 material that is curved, bent or folded into a three dimensional structure comprising: (i)
coating the object with at least one electron or X-ray curable coating; and (ii) moving the
object one or more times through one or more medium to high power, medium to high
energy electron beams or X-ray fields, where at least one electron beam and/or X-ray field is
capable of penetrating through multiple layers of said sheet material to cure areas of coating
30 outside the line of sight of said beam or field.

22. The method of claim 21 where the sheet material has an equivalent area density of at least 0.4 mm of steel.

23. The method of claim 22 where the sheet material is steel sheet.

24. A facility that comprises the following components: (i) one or more objects
5 made from a sheet material that is curved, bent or folded into a three dimensional structure
and coated with one or more electron beam or X-ray curable coatings; (ii) a conveyor system
for moving said one or more objects past an electron beam and/or X-ray field; and (iii) one or
more accelerators capable of generating one or more medium to high power, medium to high
energy electron beams and/or X-ray fields capable of penetrating through multiple layers of
10 said sheet material to cure areas of coating not in the line of sight of said beam(s) and/or
field(s).

25. The facility of claim 24 where the sheet material has an equivalent area density of at least 0.4 mm of steel.

26. The facility of claim 25 where the sheet material is steel sheet.

15